

Date: Tuesday, 1/3/2006 4:20:28 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER  
 Job Number : 25379  
 Estimate Number : 11063  
 P.O. Number : N/A Part Number : D2935  
 This Issue : 1/3/2006 S.O. No. : N/A Drawing Number : D2935 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : N/A Material : N/A  
 Due Date : 1/28/2006 Qty: 40 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est A 00.06.06 New Issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S080 5052-H32 .080 Sheet



Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s)  
 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick  
 Batch M19052

(40)

J.L 06.02.04

2.0 SHEAR SHEAR



Comment: SHEAR  
 1 blank makes 4 parts  
 Blank: 7.90" x 3.70" (+0.030" - 0.000")

J.L 06.02.04

40

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per folio FA073  
 Tumble  
 Deburr any rough edges after tumbling

N/A → S/A

J.L 06.02.04

40

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.04

40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 12 Date: 06/03/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SADDLE SPACER

Job Number: 25379

Part Number: D2935

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



(40)

Comment: SECOND CHECK

M8

06/02/04

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a. ~ 06-03-17

(40)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/03/17

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST395

06/03/21

(40)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/23

(40)

Job Completion



06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

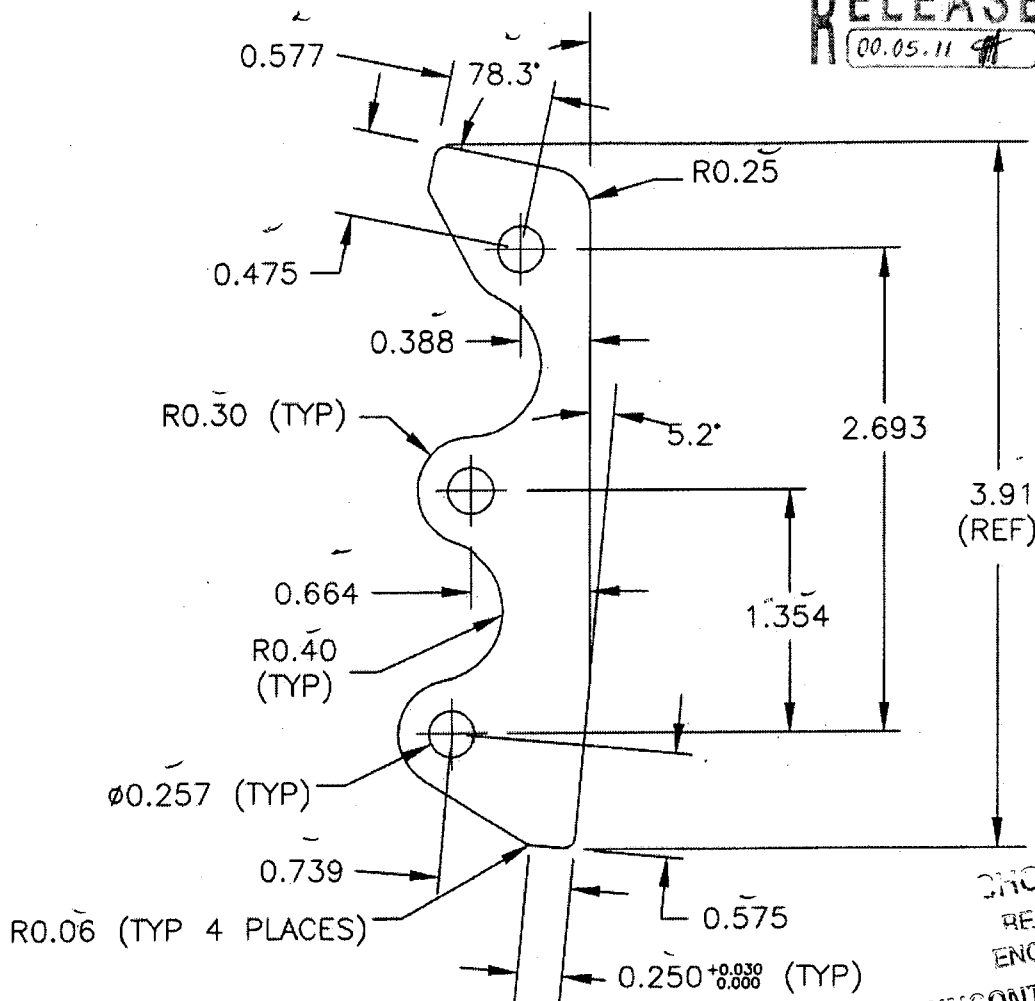
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2935	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	

RELEASED  
00.05.11 [Signature]



CHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO  
WITH HOLDING  
WORK

NO 25379

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD		Work Order: 25379
Description: saddle spacer		Part Number: D2935
Inspection Dwg: D2935 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.577	$\pm .010$	.580	✓			
.475	..	.473	✓			
.388	..	.387	✓			
r.30	$\pm .030$	.300	✓			
.664	$\pm .010$	.663	✓			
r.40	$\pm .030$	.400	✓			
Ø.257	$\begin{matrix} +.006 \\ -.001 \end{matrix}$	.259	✓			
.739	$\pm .010$	.739	✓			
r.060	$\begin{matrix} + \\ -.030 \end{matrix}$	.060	✓			
.250	$\begin{matrix} +.030 \\ -0 \end{matrix}$	.265	✓			
.575	$\pm .010$	.579	✓			
1.354	..	1.354	✓			
2.693	..	2.693	✓			
3.91	$\pm .030$	3.918	✓			
r.25	..	.25	✓			

Measured by: J.L	Audited by: MB	Prototype Approval: N/A
Date: 06-02-04	Date: 06/02/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	